

Date: Monday, 19/01/2009 2:06:12 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BO 105 SKID TUBE 'I' BEAM
Job Number : 44895	
Estimate Number : 11075	
P.O. Number :	Part Number : D2976
This Issue : 19/01/2009 S.O. No. :	Drawing Number : D2976 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : A1
Previous Run : 42623	Material :
Written By :	Due Date : 30/01/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 09.01.20</u>	
Comment : Est. C 02.10.30 Re-format KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2963084	Extrusion
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Comment: Qty.: 2.1000 Each(s)/Unit Total : 8.4000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2963-084 Extrusion 14459 * 3 / 28673

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

Cut D2963-084 extrusion to length: (82.00")

Use Jig DT8546 to drill pilot holes

Open holes to finish size per dwg D2976

Deburr

AWM 9-1-21

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AWM 9-1-21

(4)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 09/01/21 (24)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: L-6 AWM 9-1-21

(4)

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Drawing Name: BO 105 SKID TUBE 'I' BEAM

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Part Number: D2976

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/26 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

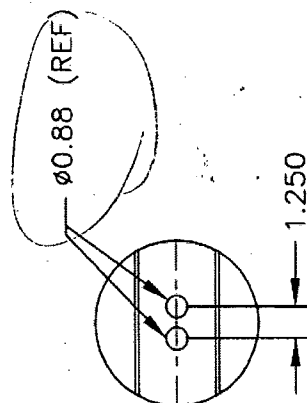
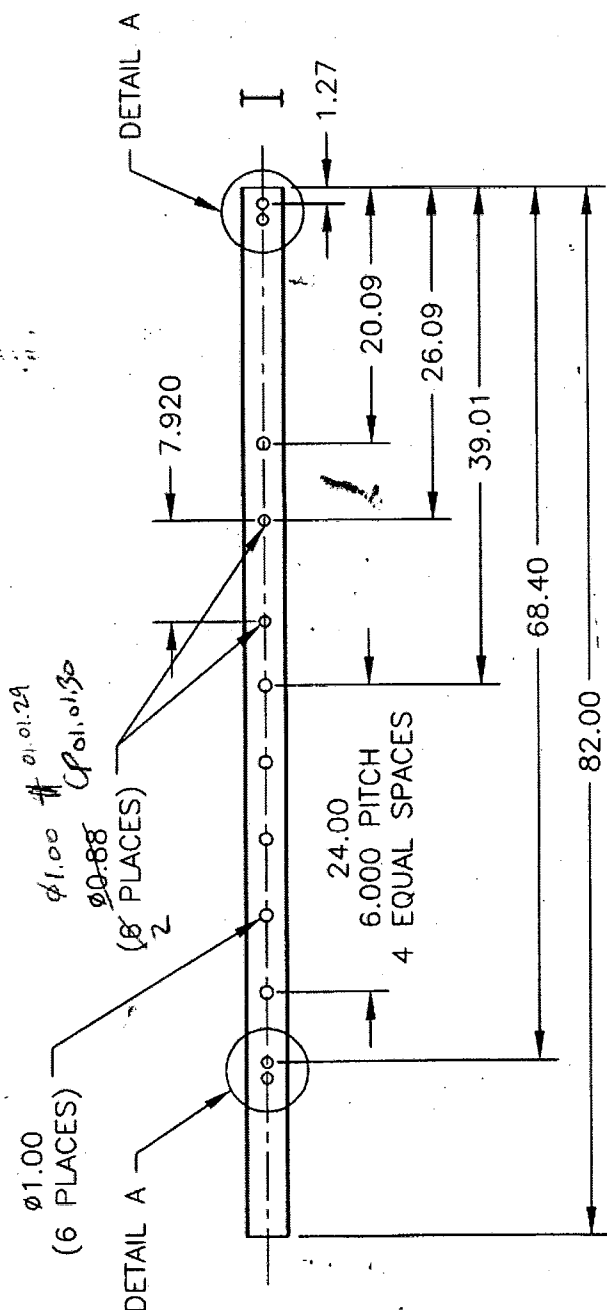


MF 09-01-22



DESIGN RF		DRAWN BY RF		DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D2976 REV. A SHEET 1 OF 1	
DATE 00.03.14		TITLE WEB		SCALE 1:14	
A	00.03.14		NEW ISSUE		
AI	01.01.29		OPEN GROUND HANDLING HOLES TO \$1.00		

RELEASED
00.05.11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44895

MAKE FROM D2963-084 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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